

82563

Work Order ID 59765

Thursday, June 10, 2010 2:45:52 PM



Page 1

Item ID: D205-633-011

Accept



Setup Start



Revision ID:

Item Name: Heli-Access-Step

Stop



Start Date: 6/10/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 6/25/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

R

Date: 10-6-10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP205-633-011 CHG001

8.266125

10/06/24

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

6/10/25

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8.10/06/25

HL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D205-633-011

Accept



Setup Start



Revision ID:

Item Name: Heli-Access-Step

Stop



Start Date: 6/10/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 6/25/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D205-633-011 Location: <u>70</u>								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

Rev 4

10.6.25

10.6.25

02/10/6/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 1 16

Work Order ID: 59765

Parent Item: D205-633-011

Parent Item Name: Heli-Access-Step

Comments: IPP Rev:F 02.07.11 Reformat; Removed D3010 RF

Start Date: 6/10/2010

Required Date: 6/25/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-14A Bolt		Purchased	No			110	Each	360.0000	1	6			

Location Loc Qty Loc Code

ST357 344
114582 44
114752 300
ST358 16
113359 16

114752

AN4-5A Bolt

Purchased No

110 Each 230.0000 2

12

Location Loc Qty Loc Code

ST356 230
114108 30
114330 200

114108

AN4-6A Bolt

Purchased No

110 Each 773.0000 2

12

Location Loc Qty Loc Code

ST356 773
112933 96
113149 600
114523 2
114615 75

113149

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 59765

Parent Item: D205-633-011

Parent Item Name: Heli-Access-Step






Comments: IPP Rev:F002.07.11 Reformat; Removed D3010 ☐ RF ☐

Start Date: 6/10/2010

Required Date: 6/25/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-7A  Sf Bolt		Purchased	No			110	Each	194.0000	2	112			
<div> <div>Location</div> <div>ST356</div> <div>113226</div> </div> <div> <div>Loc Qty</div> <div>194</div> <div>194</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
AN5-14A  Sf Bolt		Purchased	No			110	Each	70.0000	1	113224 16			
<div> <div>Location</div> <div>ST338</div> <div>112411</div> <div>112489</div> </div> <div> <div>Loc Qty</div> <div>70</div> <div>20</div> <div>50</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
AN5-6A  Sf Bolt		Purchased	No			110	Each	46.0000	1	112411 16			
<div> <div>Location</div> <div>ST337</div> <div>112243</div> </div> <div> <div>Loc Qty</div> <div>46</div> <div>46</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
AN9600D516  Sf Washer	NAS1149D0463J	Purchased	No			110	Each	18.0000	15	112243 90 11500			
<div> <div>Location</div> <div>ST357</div> <div>107939</div> </div> <div> <div>Loc Qty</div> <div>18</div> <div>18</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
AN9600D516  Sf Washer	NAS1149D0563J	Purchased	No			110	Each	0.0000	4	24 113706			

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 59765

Parent Item: D205-633-011

Parent Item Name: Heli-Access-Step

Comments: IPP Rev:F02.07.11 Reformat; Removed D3010 ☐ RF ☐

Start Date: 6/10/2010

Required Date: 6/25/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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S46 D2021-101 Eyebolt		Manufactured	No			110	Each	15.0000	1	16			
--------------------------	--	--------------	----	--	--	-----	------	---------	---	----	--	--	--

Location Loc Qty Loc Code

ST004 15

59159 15

S46 D2022-101 Spacer		Manufactured	No			110	Each	200.0000	2	12			
-------------------------	--	--------------	----	--	--	-----	------	----------	---	----	--	--	--

Location Loc Qty Loc Code

ST504 200

50746 100

52325 100

S46 D2022-103 Spacer		Manufactured	No			110	Each	118.0000	2	12			
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Location Loc Qty Loc Code

ST004 118

47964 118

S46 D2562-001 Strut		Manufactured	No			110	Each	4.0000	1	6			
------------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Location Loc Qty Loc Code

ST264 4

59217 4

S46 D2563 Step Weldment Assembly		Manufactured	No			110	Each	0.0000	1	6			
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 59765

Parent Item: D205-633-011

Parent Item Name: Heli-Access-Step

Comments: IPP Rev:F02.07.11 Reformat; Removed D3010 RF

Start Date: 6/10/2010

Required Date: 6/25/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
S 46 D2565-101 Strut		Manufactured	No			110	Each	5.0000	1	6			
				<u>Location</u>									
				ST270				5					
				59218				5					
S 46 D2565-103 Strut		Manufactured	No			110	Each	7.0000	1	6			
				<u>Location</u>									
				ST270				7					
				59219				7					
S 46 D2565-105 Strut		Manufactured	No			110	Each	7.0000	1	6			
				<u>Location</u>									
				ST270				7					
				59220				7					
S 46 D2565-107 Strut		Manufactured	No			110	Each	5.0000	1	6			
				<u>Location</u>									
				ST270				5					
				59221				5					

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 59765

Parent Item: D205-633-011

Parent Item Name: Heli-Access-Step

Comments: IPP Rev:F002.07.110Reformat; Removed D3010 0RF0

Start Date: 6/10/2010

Required Date: 6/25/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2565-109 Strut		Manufactured	No			110	Each	5.0000	1	6			
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Location Loc Qty Loc Code

ST270 5
59222 5

D2565-111 Strut		Manufactured	No			110	Each	5.0000	1				
--------------------	--	--------------	----	--	--	-----	------	--------	---	--	--	--	--

Location Loc Qty Loc Code

ST270 5
59223 5

MS21042L4 Nut		Purchased	No			110	Each	3,820.000	8	48			
------------------	--	-----------	----	--	--	-----	------	-----------	---	----	--	--	--

Location Loc Qty Loc Code

ST139 2
111827 2
ST300 3818
113422 68
114523 742
114718 1000
114784 2000
9063 8

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Thursday, June 10, 2010 2:45:57 PM

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Work Order ID: 59765



Parent Item: D205-633-011



Parent Item Name: Heli-Access-Step

Start Date: 6/10/2010

Required Date: 6/25/2010

Comments: IPP Rev:F 02.07.11 Reformat; Removed D3010 RF

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21042L5		Purchased	No			110	Each	726.0000	2	12			



Nut



Handwritten signature and circled number 6

Location

Loc Qty

Loc Code

ST139

500

114813

500

ST300

226

114449

226

Handwritten number 114499

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LISTS

5.1 D205-633-011/-013/-015/-017 Heli-Access Step

QTY -011	QTY -013	QTY -015	QTY -017	Part Number	Description
X				D205-633-011	Heli-Access-Step™, High Gear
	X			D205-633-013	Heli-Access-Step™, Extended High Gear (31")
		X		D205-633-015	Heli-Access-Step™, Extended High Gear (39")
			X	D205-633-017	Heli-Access-Step™, Standard Low Gear
1			1	D2021-101	EYEBOLT
2	2	2	2	D2022-101	SPACER
2	2	2	2	D2022-103	SPACER
1				D2562-001	STRUT
		1		D2562-005	STRUT
			1	D2562-007	STRUT
	1			D2562-013	STRUT
1	1	1	1	D2563	WELDMENT ASSEMBLY
1				D2565-101	STRUT
1				D2565-103	STRUT
1				D2565-105	STRUT
1				D2565-107	STRUT
1				D2565-109	STRUT
1				D2565-111	STRUT
	1			D2565-201	STRUT
	1			D2565-203	STRUT
	1			D2565-205	STRUT
	1			D2565-207	STRUT
	1			D2565-209	STRUT
	1			D2565-211	STRUT
		1		D2565-301	STRUT
		1		D2565-303	STRUT
		1		D2565-305	STRUT
		1		D2565-307	STRUT
		1		D2565-309	STRUT
			1	D2565-401	STRUT
			1	D2565-403	STRUT
			1	D2565-405	STRUT
			1	D2565-407	STRUT
			1	D2565-409	STRUT
			1	D2565-411	STRUT
		1		D3165-1	SUPPORT ARM
	1	1		AN44-7A	EYEBOLT
2	1	1	2	AN4-5A	BOLT
2	3	3	2	AN4-6A	BOLT
2	2	2	2	AN4-7A	BOLT
1	1	1	1	AN4-14A	BOLT
	1	1		AN4-10A	BOLT
1			1	AN5-6A	BOLT
1	1	1	1	AN5-14A	BOLT
15	16	16	15	AN960JD416	WASHER
4	4	4	4	AN960JD516	WASHER
8	8	8	8	MS21042L4	NUT (or MS21042-4)
2	2	2	2	MS21042L5	NUT (or MS21042-5)

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Revision: B

Date: 07:08:21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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